

Work Order ID 97839

Thursday, February 28, 2013 11:29:26 AM

97839*Ship March* *Yth* Page 1

Item ID: D4268-3

Accept

***N900040100***Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Instrument Panel (212)

Start Date: 2/28/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/7/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *3-2-28*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4268

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg (D4268-3)

Dwg Rev: *A*Prog Rev: *A**2024.040*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

*4 0 Jm1333**4 0 Jm1333*

Work Order ID 97839

97839

Page 2

Thursday, February 28, 2013 11:29:26 AM

Item ID: D4268-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Instrument Panel (212)

Start Date: 2/28/2013 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 3/7/2013 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
13.3.4

4

130

Memo
1- C'sink holes as per dwg
2- Bend as per dwg

0.00

130

Small Fab

0.00

Small Fab

4x

4

SB 13/03/04
SB 13/03/04

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Shp
13.3.4

4

Work Order ID 97839***97839***

Page 3

Thursday, February 28, 2013 11:29:26 AM

Item ID: D4268-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Instrument Panel (212)

Start Date: 2/28/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 3/7/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

4 0 0 13.03.04

160

Spray Painting per QSI005 4.2

0.00

160

SprayPaint

Memo Yellow 122888

0.00

Spray Painting

Prime per QSI 4.2 and as per dwg

4 0 0 13-3-5

170

QC14- Inspect Spray Paint

0.00

170

QC

Memo

0.00

Quality Control

4

DAS
05
13.03.05

Work Order ID 97839

Thursday, February 28, 2013 11:29:26 AM

97839

Page 4

Item ID: D4268-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Instrument Panel (212)
 Start Date: 2/28/2013 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/7/2013 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location <i>SLP</i>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

13-3-5

13/3/5

13-3-5

Picklist Print

Thursday, February 28, 2013 11:29:25 AM

Page 1

Work Order ID: 97839

Parent Item: D4268-3

Parent Item Name: Instrument Panel (212)

Start Date: 2/28/2013

Required Date: 3/7/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 11.02.07 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

2024-T3 .040 sheet

Purchased

No

100

sf

209.2877

0.0744

~~0.3132~~ 2632
0.5

Jm B-33

Location

Loc Qty

Loc Code

MAT022

209.2876922

120605

65.8254832

121197

57.187894

122136

31.78

123217

54.494315

1232.7

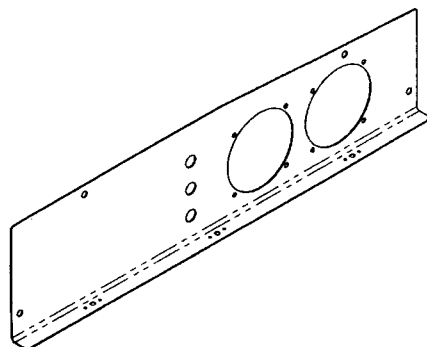
DART AEROSPACE LTD		Work Order: 97837
Description: Instrument Panel		Part Number: D4268-3
Inspection Dwg: D4268	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

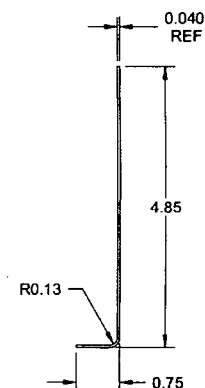
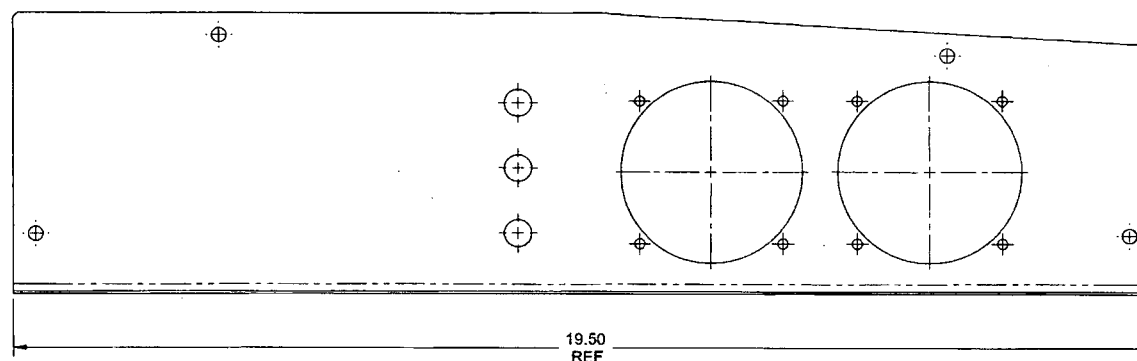
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098"	-		U	Jkmol
Ø0.177	+0.005/-0.001	0.178"	-		U	
Ø0.191	+0.005/-0.001	0.191"	-		U	
Ø0.250	+0.005/-0.001	0.253"	-		U	
Ø0.470	+0.006/-0.001	0.471"	-		U	
Ø3.150	+0.012/-0.001	3.151"	-		U	
Ø3.505	+0.012/-0.001	3.506"	-		U	
4.95	+/-0.030	4.95"	-		U	
2.478	+/-0.010	2.478"	-		V	
1.239	+/-0.010	1.239"	-		V	
1.65	+/-0.030	1.650"	-		V	
2.75	+/-0.030	2.753"	-		V	
19.50	+/-0.030	19.50"	-		T	Jkm06
12.50	+/-0.030	12.50"	-		T	
6.00	+/-0.030	6.009"	-		V	
3.50	+/-0.030	3.512"	-		V	
0.350	+/-0.010	0.353"	-		V	
0.344	+/-0.010	0.346"	-		V	
0.688	+/-0.010	0.692"	-		V	
1.69	+/-0.030	1.683"	-		V	
1.13	+/-0.030	1.130"	-		V	
2.26	+/-0.030	2.271"	-		V	
5.50	+/-0.030	5.498"	-		V	
0.38	+/-0.030	0.378"	-		V	
3.50	+/-0.030	3.479"	-		V	
8.60	+/-0.030	8.603"	-		V	
10.00	+/-0.030	10.000"	-		V	Producing
3.80	+/-0.030	3.804"	-		V	
3.75	+/-0.030	3.754"	-		V	
3.50	+/-0.030	3.505"	-		V	
1.239	+/-0.010	1.239"	-		V	
0.040	+/-0.010	0.039"	-		V	

Measured by: Jm	Audited by: AS	Preliminary Approval:
Date: 13-3-3	Date: 27/13/34	Date:

Rev	Date	Change	Revised by	Approved
A	11.04.28	New Issue	P/O D4268-043 KJ	



97839



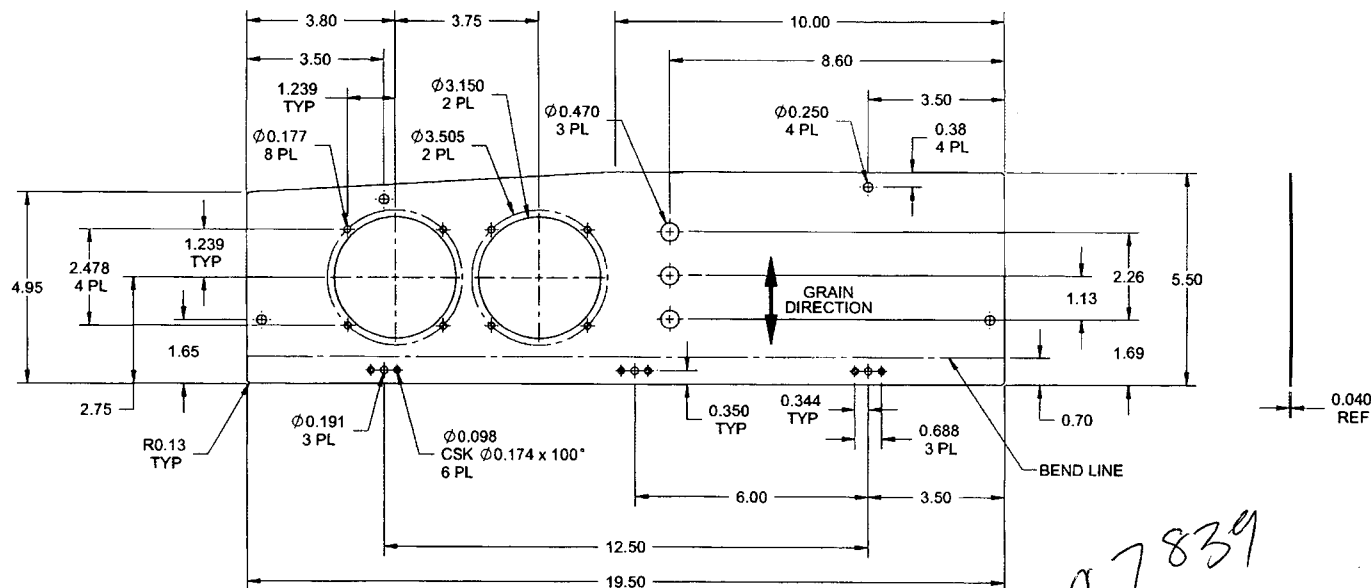
D4268-3 INSTRUMENT PANEL (212/412)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

RELEASED
2011-04-06

NOTES:

- 1) MATERIAL: MAKE FROM D4268-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 AND PRIME PER QSI 005 4.2.1 *Yellow*
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4268	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE VRD PARTS	SHEET 5 OF 12
APPROVED	<i>[Signature]</i>	SCALE	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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D4268-3F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-15-412)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs

RELEASED
2011-04-06
NW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4268	REV. A
MFG. APPR.			SHEET 6 OF 12
APPROVED		TITLE VRD PARTS	SCALE NTS
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